

Work Order ID 59305

Monday, May 31, 2010 1:02:49 PM

SPC



Page 1

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: ~~10.00~~ (8)



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: ~~10.00~~



Customer:

Reference:

Approvals:

Process Plan: *H*

Date: *10-6-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3572	Rev D

100 Pick Kit 0.00



Packaging

Packaging

*EZ 10-6-3 x/10*

110



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

*EZ 10-6-3 x/10*

1-Cut Tube D3572-1 as per Dwg D3572  
2-deburr both ends

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*S 10-6-3*

*(410)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 59305**

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Monday, May 31, 2010 1:02:50 PM

Item ID: D3572-041

Accept



Setup

Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Large Fab

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Weld per dwg A/R Aluminum rod Batch:

0.00

Large Fab

M112860

Memo

0.00

Large Fab

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572  
2- grind weld flush at the end of tube only

EZ 10-6-7 (x8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

BE 10/06/07 (x8)

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

S. w/66108

(x8) \_\_\_\_\_

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Page 3

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Setup

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Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

⑧

BL 106-8.

Hand Finishing

190



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

→ M 10/06/10

8 8

Powder Coating

Memo

START TIME: 11:45 AM  
OVEN TEMPERATURE: 320° F  
FINISH TIME: 12:15 PM

0.00

200



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

M 10 06 10 ⑧

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 4

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Item Name: Guide Assembly

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Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

210

Operation  
DescriptionIdentify as per dwg & Stock Location 260Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Packaging

Memo

0.00

10-6-11



220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/11

CZ 10/6/11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

# Picklist Print

Page 1

Monday, May 31, 2010 1:02:55 PM

Work Order ID: 59305



Parent Item: D3572-041



Parent Item Name: Guide Assembly

Start Date: 5/31/2010

Required Date: 6/7/2010

Comments: IPP Rev:A New Issue 07-02-07 JLM

Start Qty: 10.00

Required Qty: 10.00

IPP rev B revB dwg EC

IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM

IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

M6061T6T1.000W.188

Purchased No

110

f

98.1240

2.34

24.63158

6061T6 RD TUBE 1.00 X .188W



PL 10-6-3

Location	Loc Qty	Loc Code
MAT	24.375	
114520	24.375	11.4.
MAT016	73.749	
113511	26.916	11.4
114089	46.833	

D3572-3



Manufactured No

130

Each

0.0000

4

40

B59142 X 35



PL 10-6-3

Guide

D3572-5



Manufactured No

130

Each

18.0000

1

10



Q 10-6-3

Bracket

Location	Loc Qty	Loc Code
WA	18	
54119	18	29

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

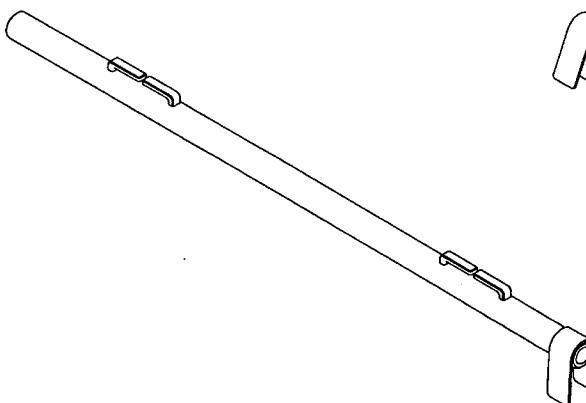
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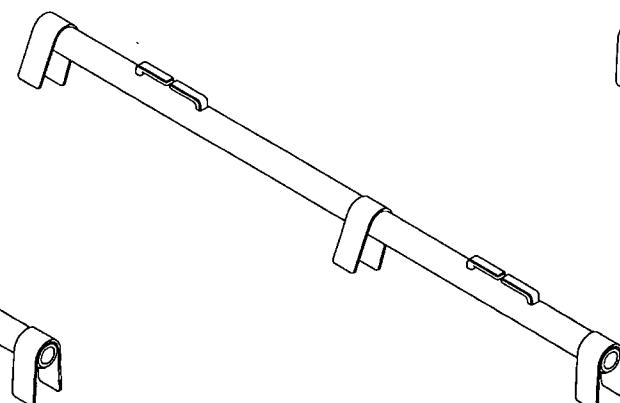
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3		X		D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

S1  
 R  
 ENGR  
 UNCONTROLLED  
 SUBJECT TO A  
 WITHOUT N  
 WORK ORD  
 NO. 59305  
 p10-3-3

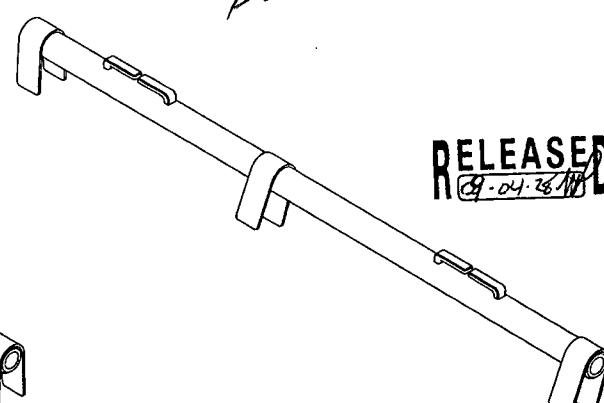
RELEASED  
09-04-16



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:  
 1) MATERIAL: NONE  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT -041: 1.34 lbs  
 -043/-044: 1.42 lbs  
 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3572-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN LF		DART AEROSPACE LTD	
DRAWN AJS		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
DATE 09.04.17		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

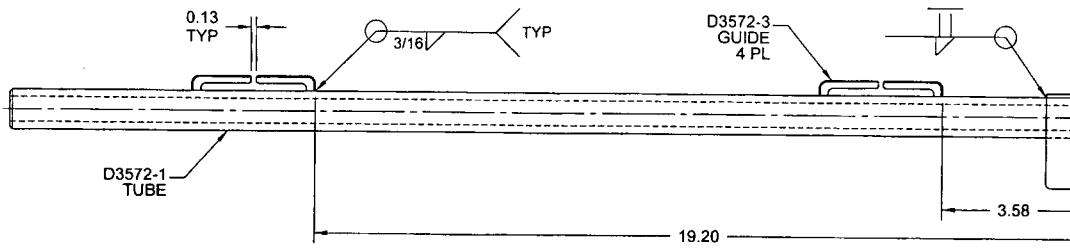
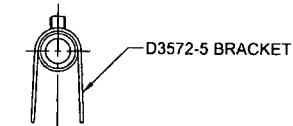
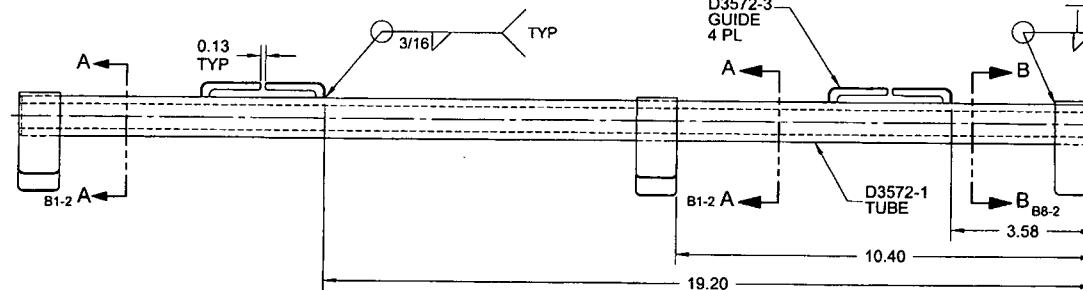
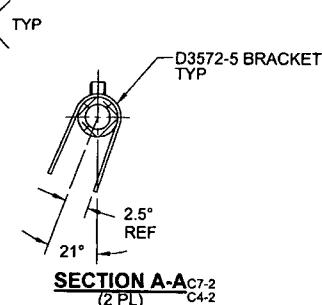
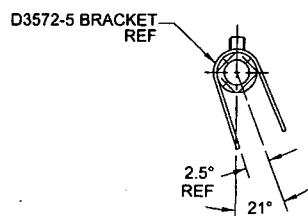
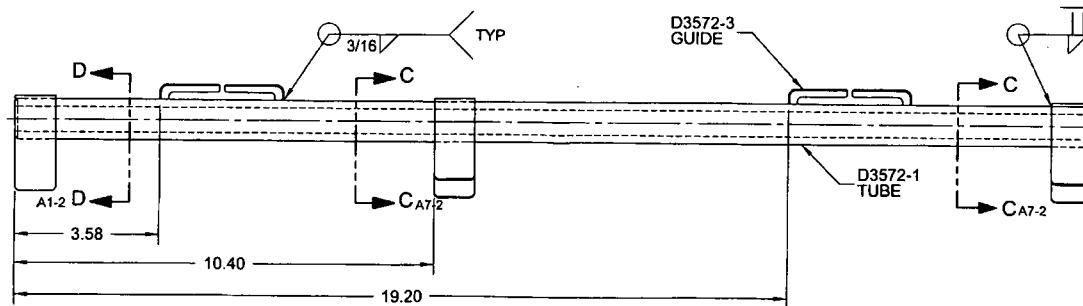
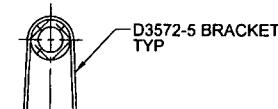
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

**D3572-041 GUIDE ASSEMBLY****SECTION B-B** C2-2**D3572-043 GUIDE ASSEMBLY****RELEASED** 09.04.17**SECTION C-C** A2-2 A5-2**D3572-044 GUIDE ASSEMBLY****SECTION D-D** A7-2

DESIGN	LE	DART AEROSPACE LTD
DRAWN	A.J.S	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO. D3572
MFG. APPR.	<i>AB</i>	REV. D
APPROVED	<i>AB</i>	SHEET 2 OF 4
DE APPR.	<i>AB</i>	TITLE
DATE	09.04.17	SCALE
		NTS

*W/0 59306*

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8 7 6 5 4 3 2 1

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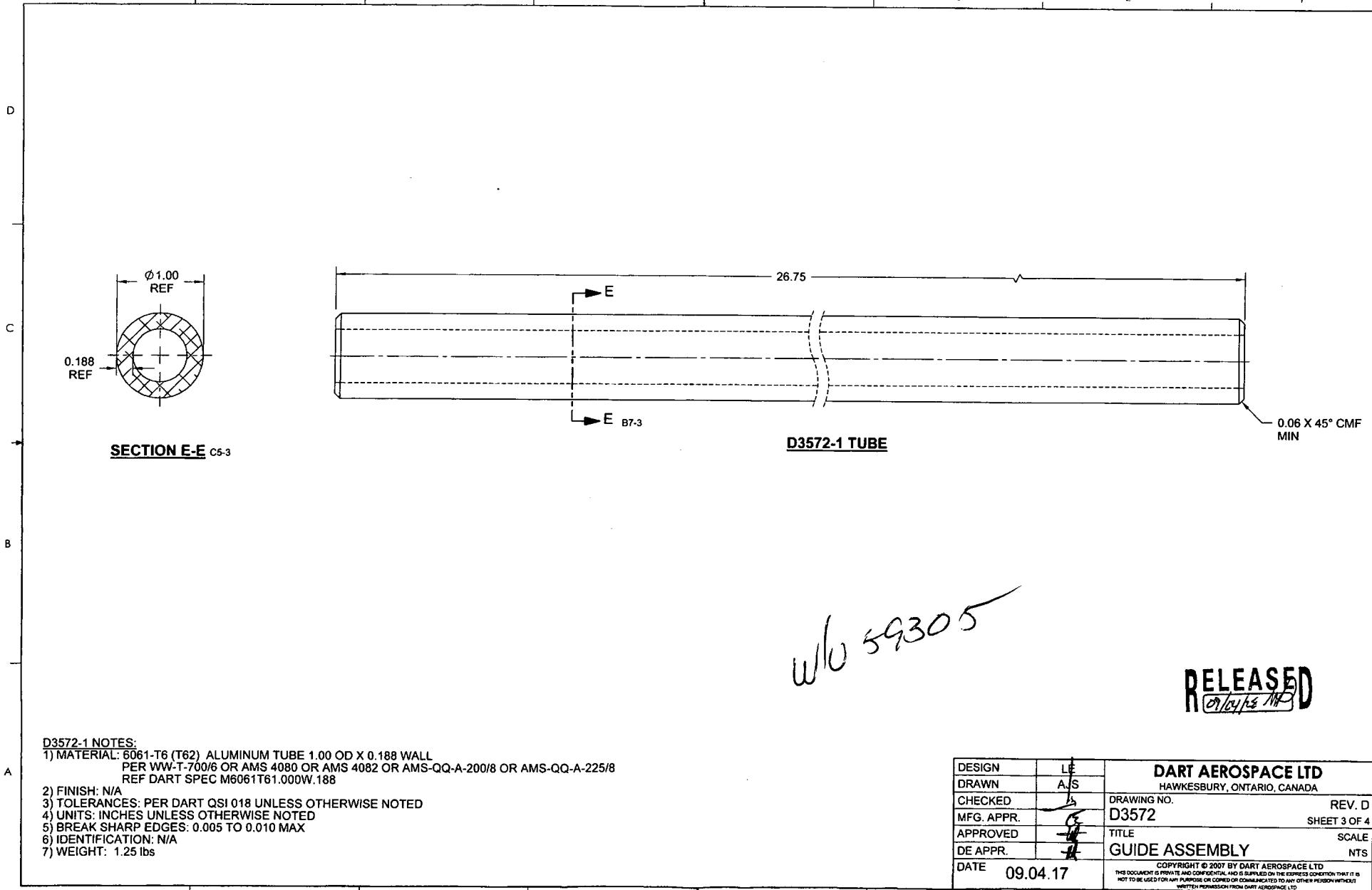
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8 7 6 5 4 3 2 1



D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>✓</i>	DRAWING NO. D3572	
MFG. APPR.	<i>✓</i>	REV. D	SHEET 3 OF 4
APPROVED	<i>✓</i>	TITLE	SCALE
DE APPR.	<i>✓</i>	GUIDE ASSEMBLY	
DATE	09.04.17	NTS	

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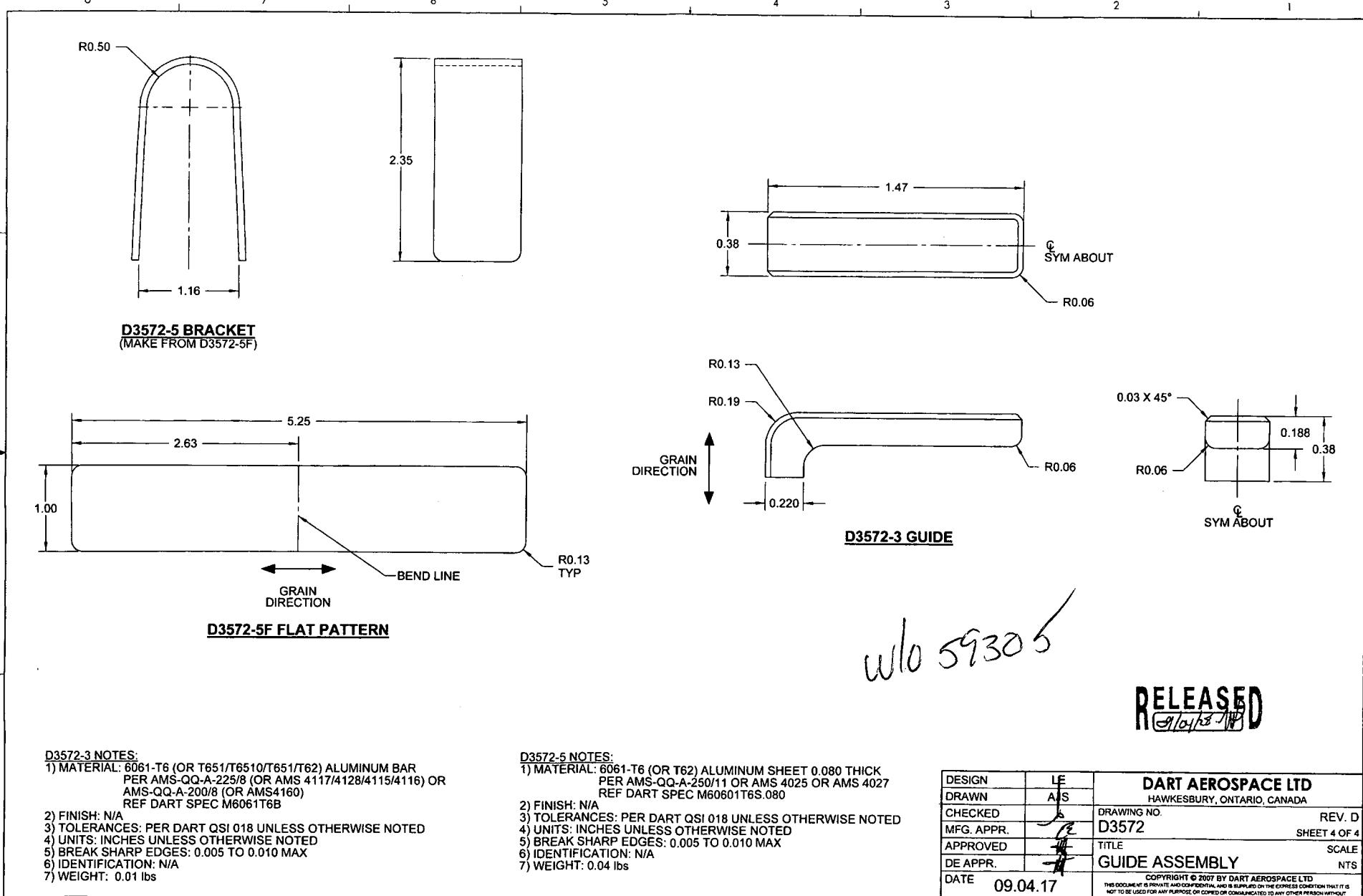
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WLO 59305

RELEASED  
*[Signature]*

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